

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010116**Date Inspected:** 03-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	NA	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

South of Blast Bay-

This QA Inspector performed Ultrasonic Testing verification (UT) of OBG segment 7AW welds. Ultrasonic testing was performed on Complete Joint Penetration (CJP) welds tested and accepted by ZPMC as well as CJP welds not tested by ZPMC UT technicians. For further detail please see the TL-6027 UT report generated this date. The following welds were tested:

Deck panel diaphragm splice welds: SEG033-PP48-011~018

Floor beam splice welds: SSD13-PP48-002, 008, 131, 132 and 138. Caltrans QA found weld SSD13-PP48-131 to be unacceptable as per AWS D1.5 table 6.3.

Corner assembly welds: CA031-003, 004, CA032-003 and 004.

Bay 13

This QA inspector performed Ultrasonic Testing (UT) verification of the areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member was

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identified as OBG Segment 11BE side panel to bottom panel weld, SEG068A-005. Caltrans QA found weld SEG068A-005 to be unacceptable as per AWS D1.5 table 6.3. ZPMC is required to perform 25% testing of this joint. For further detail please see the TL-6027 UT report generated this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer
